

Work Order ID 80706

80706

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February-27-12 2:55:14 PM

Item ID: D3529-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bearpaw
 Start Date: 27/02/2012 Start Qty: 8.00 *8* Cust Item ID:
 Required Date: 12/03/2012 Req'd Qty: 8.00 *8* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/02/27 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3529	Rev A								

110 FLOW WATER JET 0.00
 110
 Waterjet Memo 0.00
 FLOW CNC Waterjet CUT BLANK AS PER FILE D3529-1BLANK

B12-3-3

(8)

120 HAAS CNC VERTICAL MACHINING #1 0.00
 120
 HAAS 1 Memo 0.00
 HAAS CNC vertical machine #1 1-Inspect material for defects or damage prior to machining2-Machine as per Folio FA645 and Dwg D35293-Deburr

PO/12/03/11

8

Ø

130 QC2- Inspect parts off machine FAI/FAIB 0.00
 130
 QC Memo 0.00
 Quality Control

PO/12/03/11

8

Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC8- Inspect parts - second check	0.00							
140									
QC	Memo	0.00							
Quality Control									
150	Identify as per dwg & Stock Location: _____	0.00							
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

PP80705

8x Sp 12-03-13

12/3/14

12-03-13

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Picklist Print

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Work Order ID: 80706

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Parent Item: D3529-1

D3529-1

Parent Item Name: Bearpaw

Start Date: 27/02/2012

Required Date: 12/03/2012

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP Rev:A New Issue 06-06-28 JLM

IPP Rev:B New Manufacturing Method 08-11-27 Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			100	sf	585.1243	1.265	10.65263			

MUHMWB10

**

B12-3-3

UHMW 1" Black

Location

Loc Qty

Loc Code

MAT018

327.48

120035

74.48

120401

253

MAT019

257.6443158

117321

74.6

117738

93.8

117819

83.3

118814

1.5

119145

4.44431579

120401

68

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DART AEROSPACE LTD		Work Order: 80706
Description: Bearpaw		Part Number: D3529-1
Inspection Dwg: D3529	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	5.50	+/-0.030	5.50	✓		VERN	GA-09
B	0.07 x 45°	+/-0.030 x 0.5°	0.07	✓		VERN	GA-09
C	R0.25	+/-0.030	0.25	✓		R. G.	
D	0.250	+/-0.010	0.250	✓		Mic	118 120
E	0.625	+/-0.010	0.624	✓		Mic	118 120
F	0.950	+/-0.010	0.949	✓		Mic	118 120
G	1.63	+/-0.030	1.62	✓		VERN	GA-09
H	12.14	+/-0.030	12.14	✓			31006
I							
J	5.70	+/-0.030	5.70	✓		VERN	GA-09
K	0.375	+/-0.010	0.380	✓		Mic	118 120
L	0.525	+/-0.010	0.530	✓		Mic	118 120
M	0.13 x 45°	+/-0.030 x 0.5°	0.130 x 45°	✓		VERN	GA-09
N	R0.50	+/-0.030	0.500	✓		R. G.	
O	12.76	+/-0.030	12.76	✓			31006
P	3.38	+/-0.030	3.37	✓		VERN	GA-09
Q	3.75	+/-0.030	3.75	✓			31006
R	5.187	+/-0.010	5.195	✓			31006
S	5.25	+/-0.030	5.25	✓			31006
T	7.13	+/-0.030	7.13	✓			31006
U	Ø0.260	+0.006/-0.001	0.259	✓		PIN gage	
V	0.30	+/-0.030	0.30	✓			GA-08
W	0.93	+/-0.030	0.93	✓		VERN	GA-09
X	1.30	+/-0.030	1.30	✓		VERN	GA-09

Measured by: PO/129	Audited by: B.A	Prototype Approval:	N/A
Date: 12/03/11	Date: 12/03/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.01	New Issue	KJ/JLM	
B	08.05.06	Dimension I removed	KJ/DD	

Dart Aerospace Ltd

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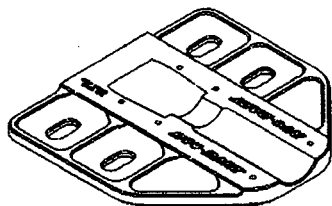
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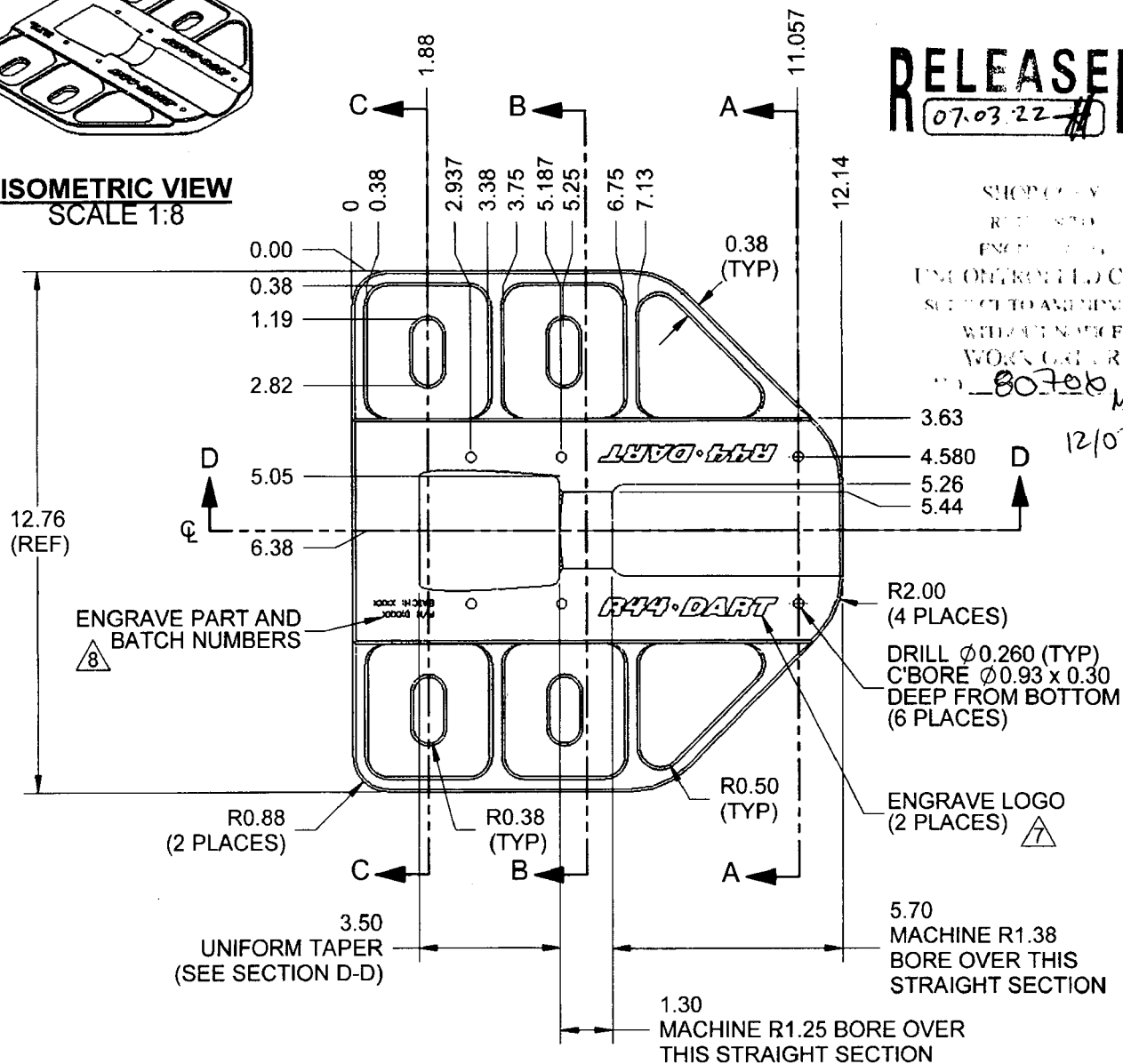
NOTE: Date & initial all entries

DART

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3529	REV. A SHEET 1 OF 2
DATE 07.01.04		TITLE R44 BEARPAW	SCALE 1:4
REV A	DATE 07.01.04	DESCRIPTION NEW ISSUE	



ISOMETRIC VIEW
SCALE 1:8

**NOTES:**

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00 THICK (MACHINE TO 0.950)
- 2) FINISH: NONE
- 3) PART IS SYMMETRIC ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) ENGRAVE LOGO TO MAX DEPTH OF 0.012 AT LOCATION SHOWN
- 8) ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010 AT LOCATION SHOWN

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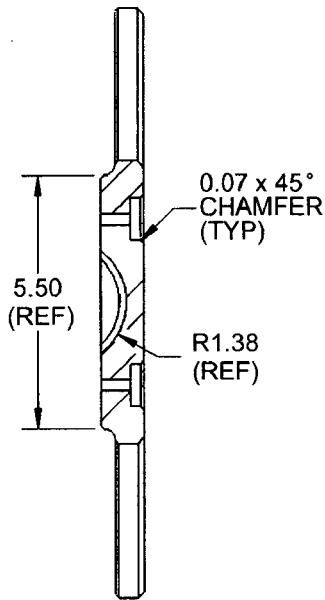
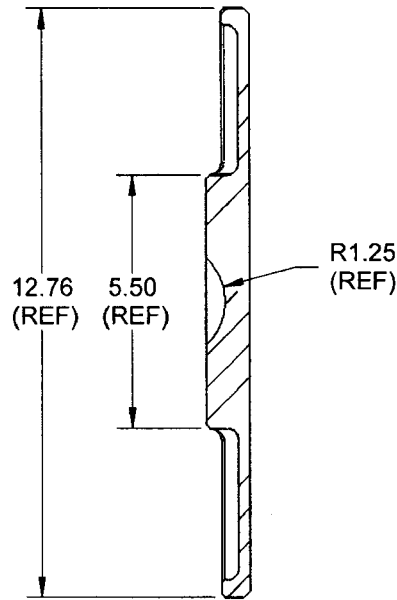
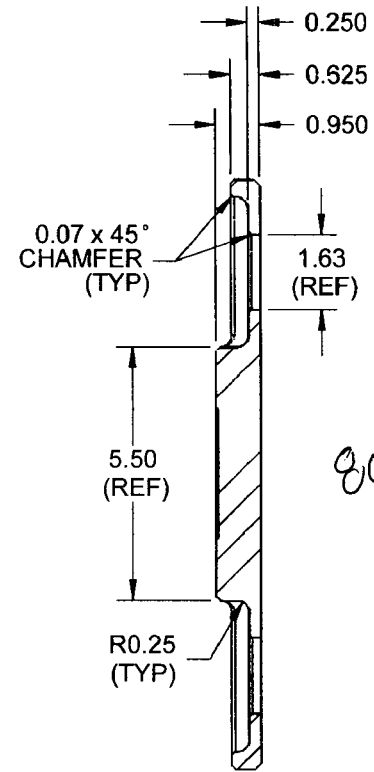
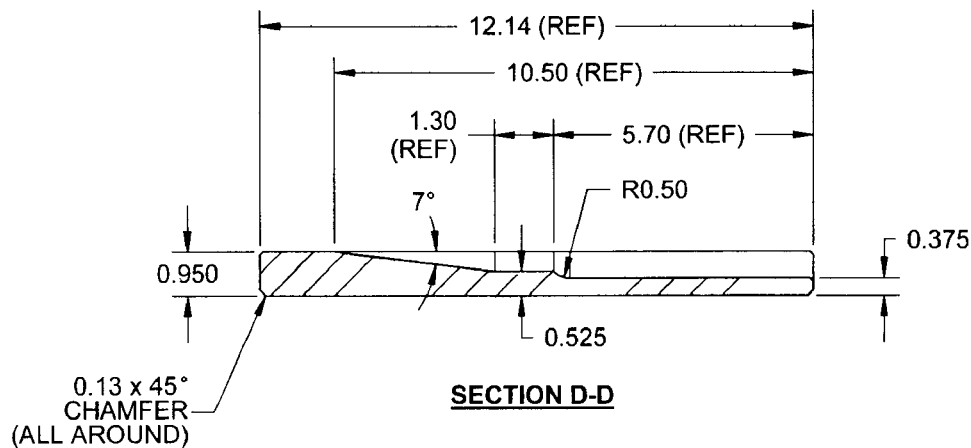
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3529	REV. A SHEET 2 OF 2
DATE 07.01.04	TITLE R44 BEARPAW		SCALE 1:4

RELEASED
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